

Work Order ID 152483

Monday, October 24, 2016 1:05:12 PM

152483 **SEE W/O 162649*

Page 1

Item ID: D3687-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mount
Start Date: 10/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/31/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plant *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3687	Rev D

100		0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks at 3.600"								

D.a 16/10/26 31 0 **DAS 08 9-09**

105		0.00							
105									
HAAS 5AXIS	Memo	0.00							
HAAS CNC vertical machine #5	1-Machine per folio FB469								
	DWG REV: <u>D</u>								
	FOLIO REV: <u>AA</u>								

D.a 16/10/26 3 1 **DAS 08 9-09**

2- deburr and break all sharp edge as per dwg

*PTO →
(last page)*

Work Order ID 152483

152483

Page 2

Monday, October 24, 2016 1:05:12 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC1- Inspection performed by CMM Memo Inspect on CMM as per folio CMMA041. DWG REV: _____ CMM PROG. REV: _____	0.00 0.01		D.2	16/10/26	3	0		DAS 08 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				3	0		DAS 49 9-89 17/05/26
124 *124* Purchasing Purchasing	Memo Issue P/O FOR LIQUID PENETRATION P/O #: 36453 36529 Certificate of conformity is required	0.00 0.00				3		JUN 02 2017	DAS 13 9-89

Work Order ID 152483***152483***

Page 3

Monday, October 24, 2016 1:05:12 PM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo ENSURE NDT RESULT IS ATTACH	0.00 0.01				3x	801762		
127 *127* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo INSPECT HOLE ALIGHMENT USING DT9707 JIG	0.00 0.00				3			DAS 38 9-89 JUN 05 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : GA	0.00 0.01				3			DAS 6 9-89 JUN 06 2017

152483

Monday, October 24, 2016 1:05:12 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Run Start *NR1*

Stop *NR2*

NR2

**Insp.
Stamp**

0.00

140

0.07

Quality Control

Picklist Print

Page 1

Monday, October 24, 2016 1:05:11 PM

Work Order ID: 152483

152483

Parent Item: D3687-1

D3687-1

Parent Item Name: Mount

Start Date: 10/26/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC
 IPP Rev:B Added Contion H-900 JLM Verified By:DD IPP REV C:
 ADDED QC6 10.09.09 JLM VERIFIED BY DD
 IPP REV D:ADDED DT9707 INSPECTION JIG 11-01-05 JLM VERIFIED
 BY:DD IPP REV E: Now
 machined in house, blank cutting length as change. JFS 16/10/24 Verified by:
 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750		Purchased	No			100	f	6.1670	0.3	1.263158			

M174PH-H900B3 937X4 750

**

H.A 16-10-26

17-4SS Bar H900-3.937x4.750

Location

Loc Qty

Loc Code

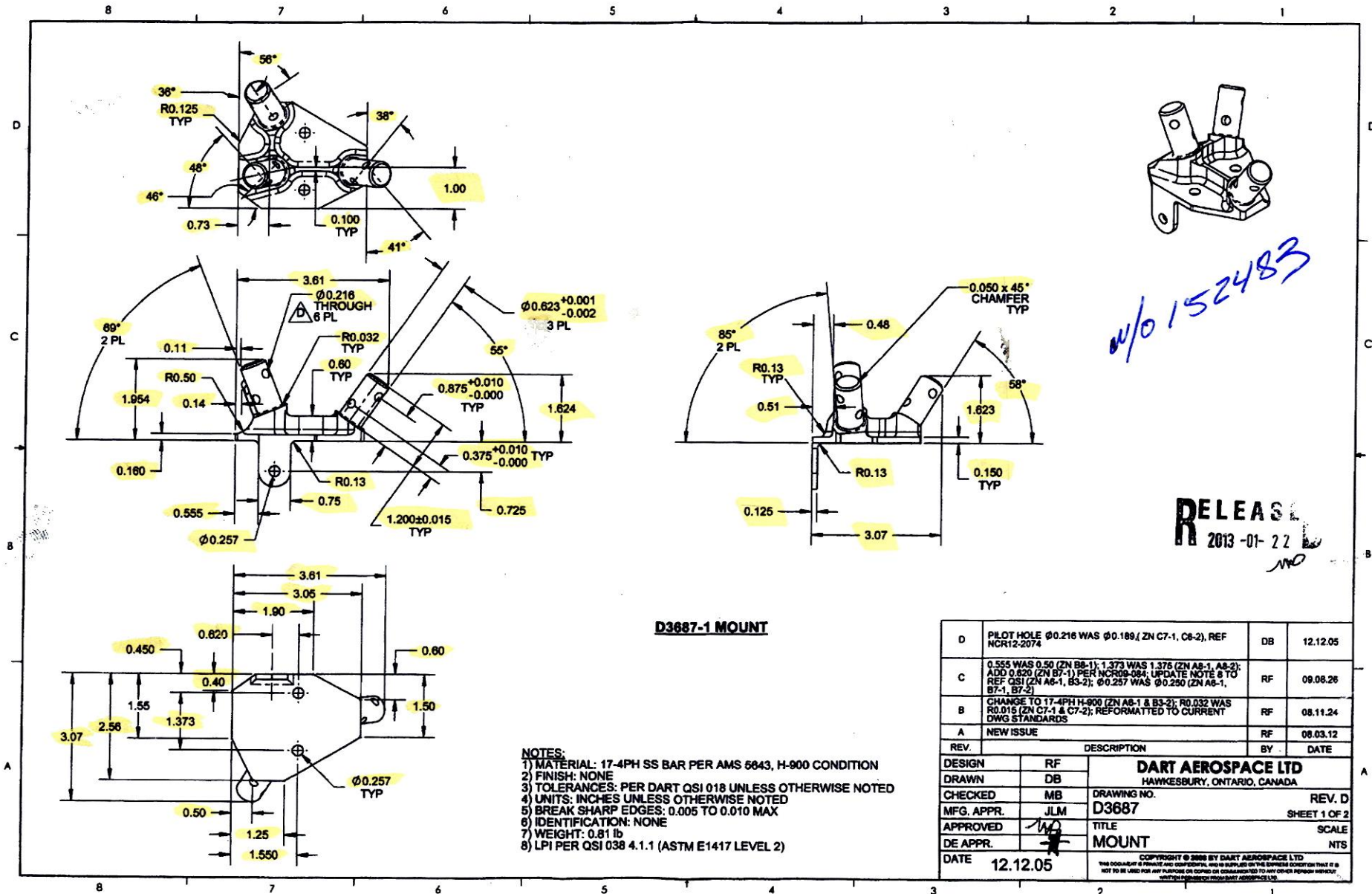
MAT010

6.167

→ m126352

6.167

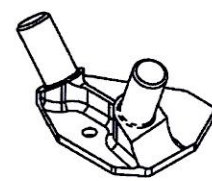
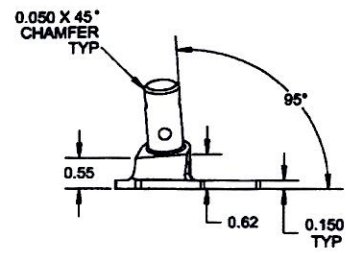
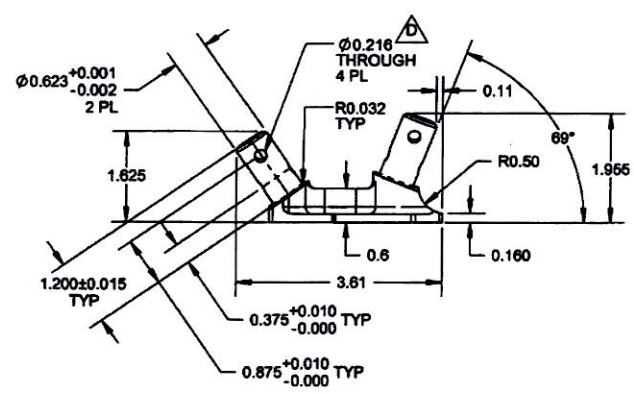
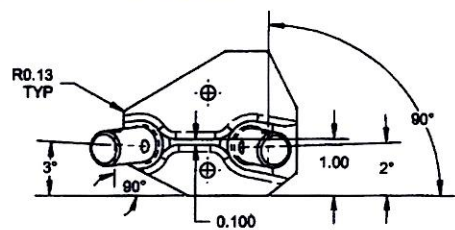
1.216ft



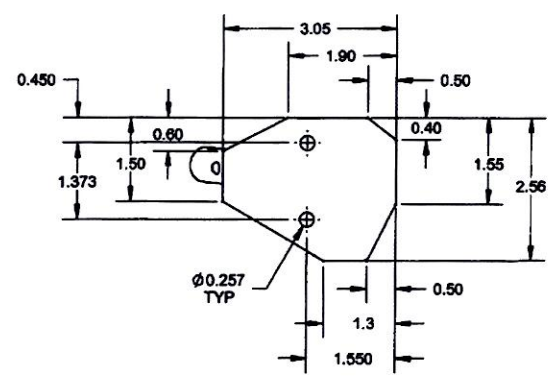
u/o 152483

RELEASE
2013-01-22

8 7 6 5 4 3 2 1



w/b 12483



- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

D3687-3 MOUNT

RELEASED
2013-01-22
MD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3687	SHEET 2 OF 2
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	MOUNT	NTS
DATE	12.12.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 152483
Description: MOUNT		Part Number: D3687-1
Inspection Dwg: D3687 Rev: D		Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38°	+/- 1/2°	38°	✓		Angle M	CNC-17
56°	+/- 1/2°	56°	✓		"	"
36°	+/- 1/2°	36°	✓		"	"
R0.125	+/- .010	R0.125	✓		R-G	ref.
48°	+/- 1/2°	48°	✓		Angle M	CNC-17
46°	+/- 1/2°	46°	✓		"	"
0.73	+/- .030	0.735	✓		H-G	31006
0.100	+/- .010	0.105	✓		Mic	GA-03
41°	+/- 1/2°	41°	✓		Angle M.	CNC-17
1.00	+/- .030	1.006	✓		H-G	31006
55°	+/- 1/2°	55°	✓		Angle M	CNC-17
φ0.623	+0.001 / -0.002	φ0.6228	✓		Mic	GA-03
0.60	+/- .030	0.593	✓		Vern	GA-13
R0.032	+/- .010	R0.030	✓		R-G	ref.
φ0.216	+0.005 / -0.001	φ0.217	✓		Vern	GA-13
3.61	+/- .030	3.621	✓		H-G	31006
69°	+/- 1/2°	69°	✓		Angle M.	CNC-17
1.954	+/- .010	1.951	✓		H-G	31006
R0.50	+/- .030	R0.500	✓		R-G	ref.
0.14	+/- .030	0.133	✓		H-G	31006
0.160	+/- .010	0.162	✓		"	"
0.555	+/- .010	0.558	✓		"	"
φ0.257	+0.006 / -0.001	φ0.258	✓		Vern	GA-13
0.75	+/- .030	0.7505	✓		Mic	GA-03
R0.13	+/- .030	R0.125	✓		R-G	ref.
1.200	+/- .015	1.200	✓		H-G	31006
0.725	+/- .010	0.726	✓		"	"
0.375	+0.010 / -0.000	0.381	✓		"	"
0.875	+0.010 / -0.000	0.881	✓		"	"
1.624	+/- .010	1.622	✓		"	"
3.61	+/- .030	3.619	✓		"	"
3.05	+/- .030	3.052	✓		Vern	GA-13

Measured by: BA DAS 08	Checked by: 9-89	QC Inspector:
Date: 16-10-26 9-89	Date: 17/05/26	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>152483</u> Part No. <u>D3687-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☒</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : <u>16-10-26</u>		Step #: <u>105</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval DAS 9 9-89 <u>17-05-26</u>																																																																	
Description Work Order Deviation				Disposition																																																																			
Toolpath was programed upside down (mirror image).				→ Program has been fixed and updated <u>DFS</u> <u>16-10-26</u>																																																																			
				Completed By <u>A.P 16-10-26</u>																																																																			
				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>17-05-26</u>																																																																			
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		OTHER : _____																																																																					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36529**

Purchase Order Date 6/1/2017
PO Print Date 6/2/2017

Page Number 2 of 4

Order From :
VC-SKY001
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$400.00

3	160610	D4881-1 STRUT	6/2/2017 Yes 6/2/2017	4.00	\$33.54	\$134.17
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LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$134.17

4	152483	D3687-1 MOUNT	6/2/2017 Yes 6/2/2017	3.00	\$44.72	\$134.17
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LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$134.17

5	159590	D212-664-101 CROSSTUBE	6/2/2017 Yes 6/2/2017	1.00	\$134.17	\$134.17
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LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Note:

6/2/2017

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO32285	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO36529
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 4 CROSSTUBES , 1 FUEL TANK , 4 STRUTS AND 3 MOUNTS AS PER PO

4 STRUTS, ITEM ID# D4881-1 , WORK ORDER ID# 160610

✓ 3 MOUNTS, ITEM ID# D3687-1 , WORK ORDER ID# 152483

1 FUEL TANK ASSY, ITEM ID# D4464-041 , WORK ORDER ID# 160160

4 FWD CROSSTUBES, ITEM ID# D212-664-101 , WORK ORDERS ID# 159589, 159590, 159591, 159592

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , EMU. MPO15896, DEV. MPO11715 , UV LIGHT M-20142						JUN 01 2017	
<i>Description</i>	<i>Location</i>	<i>P/N</i>	<i>Qty</i>	<i>Batch</i>	<i>S/N Off</i>	<i>S/N On</i>	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: JUN 01 2017
Name: RAFIK MELIKIAN		